

Work Order ID 157182

157182

Page 1

Tuesday, February 21, 2017 7:43:22 AM

Item ID: D3197-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bar

Start Date: 2/8/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 2/17/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

DAS
21
9-89

Date:

FEB 21 2017

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3197

Rev B

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks: 29.125" long

DAS
14
9-89

17/03/15

110

0.04

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.39

HAAS CNC vertical machine #1

1-Face ends to length per dwg D31972-Machine D3197-1 as per Folio FA340 and Dwg D31973-Debur

DAS
45
9-89

2017-3-15

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.01

Quality Control

DAS
45
9-89

2017-3-15

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:12.5%;">Skid-tube ☐</td> <td style="width:12.5%;">Cross tube ☐</td> <td style="width:12.5%;">Water Jet ☐</td> <td style="width:12.5%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Run Start

NR1

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Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Lathe Conv

CONVENTIONAL LATHE

0.00

Memo

0.00

Conventional Lathe

Chamfer as per Dwg D3197

4

Ø

DAS

44

9-89

17-03/16

140

140

QC

QC8- Inspect parts - second check

0.00

Memo

0.01

Quality Control

4

Ø

DAS

49

9-89

17/03/16

150

150

HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.09

Hand Finishing

X4

Ø

201703/16

BEB

DQA: _____ Date: _____



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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 <i>m 134858.</i> Memo START TIME: <u>7:20</u> OVEN TEMPERATURE: <u>320</u> FINISH TIME: <u>7:58.</u>	0.00 0.02				<u>4</u>	<u>0</u>	<u>1703:23</u>	<u>34</u> <u>988</u>
170 *170* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.01				<u>4</u>	<u>FF</u>		<u>DAS</u> <u>38</u> <u>MAR 23 2017</u>
180 *180* Small Fab Small Fab	Small Fab Memo Assemble D3197-041 as per Dwg D3197	0.00 0.20				<u>2</u>	<u>FF</u>		<u>MAR 30 2017</u>

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.01				2			DAS 38 9-89 MAR 3 11 2017
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <u>57233</u> Memo	0.00 0.01				2			DAS 6 9-89 MAR 3 11 2017
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.07							17/4/3 JF DAS 21 9-89 MAR 3 11 2017

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157182

Parent Item: D3197-041

D3197-041

Parent Item Name: Bar

Start Date: 2/8/2017

Required Date: 2/17/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev: A New Issue 05-11-08 JLM
IPP Rev: B As per Rev B 06-03-10 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS27039-1-24		Purchased	No			100	Each	76.0000	2	8			
MS27039-1-24									**				
Screw													

Location	Loc Qty	Loc Code
ST279	76	
<u>m134537</u>	76	

FF

MAR 23 2017

D2690-5
D2690-5
Lanyard Assembly

Manufactured No

180 Each 4.0000

FF

MAR 23 2017

Location	Loc Qty	Loc Code
ST009	4	
155597	4	

2
8 6

D3242-1
D3242-1
Tag

Manufactured No

180 Each 11.0000

FF

March 23-17

Location	Loc Qty	Loc Code
GA	11	
135074	2	
<u>152857</u>	3	
<u>154878</u>	6	

7
1

D3489-3-200
D3489-3-200
Pip Pin

Manufactured No

180 Each 10.0000

FF

March 23-17

Location	Loc Qty	Loc Code
GA	10	
152735	8	
<u>154114</u>	2	

3
2

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Parent Item Name: Bar

Start Date: 2/8/2017

Required Date: 2/17/2017

Start Qty: 4.00

Required Qty: 4.00

M7075T73R1.000

Purchased

No

180

f

14.0160

2.42

12.1

M7075T73R1 000

7075-T73 Rd Bar 1.00

Location

Loc Qty

Loc Code

MAT

14.016

m134522

6.88

→ m136396 2

7.136

7.136

2,227.000

2

8

2/17/03/15

MS21042L3

2 M137041X 5.1

Purchased

No

180

Each

MS21042L3

Nut

FF

MAR 7 3 2017

Location

Loc Qty

Loc Code

FP001

100

m135945

100

GA

318

m134360

108

m135135

18

M136665

192

8

OVER007

300

m134360

0

M136665

300

ST303

509

M136406

9

M136554

500

ST3030

1000

M136838

1000

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

Picklist Print

Tuesday, February 21, 2017 7:43:26 AM

Page 3

Work Order ID: 157182

157182

Parent Item: D3197-041

D3197-041

Parent Item Name: Bar

Start Date: 2/8/2017

Required Date: 2/17/2017

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0363J

Purchased

No

180

Each

1,027.000

6

24

NAS1149D0363J

FF

MAR 23 2017

Washer

Location

Loc Qty

Loc Code

GA

197

m134055

197

ST263

830

m136318

23

m136781

807

24

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

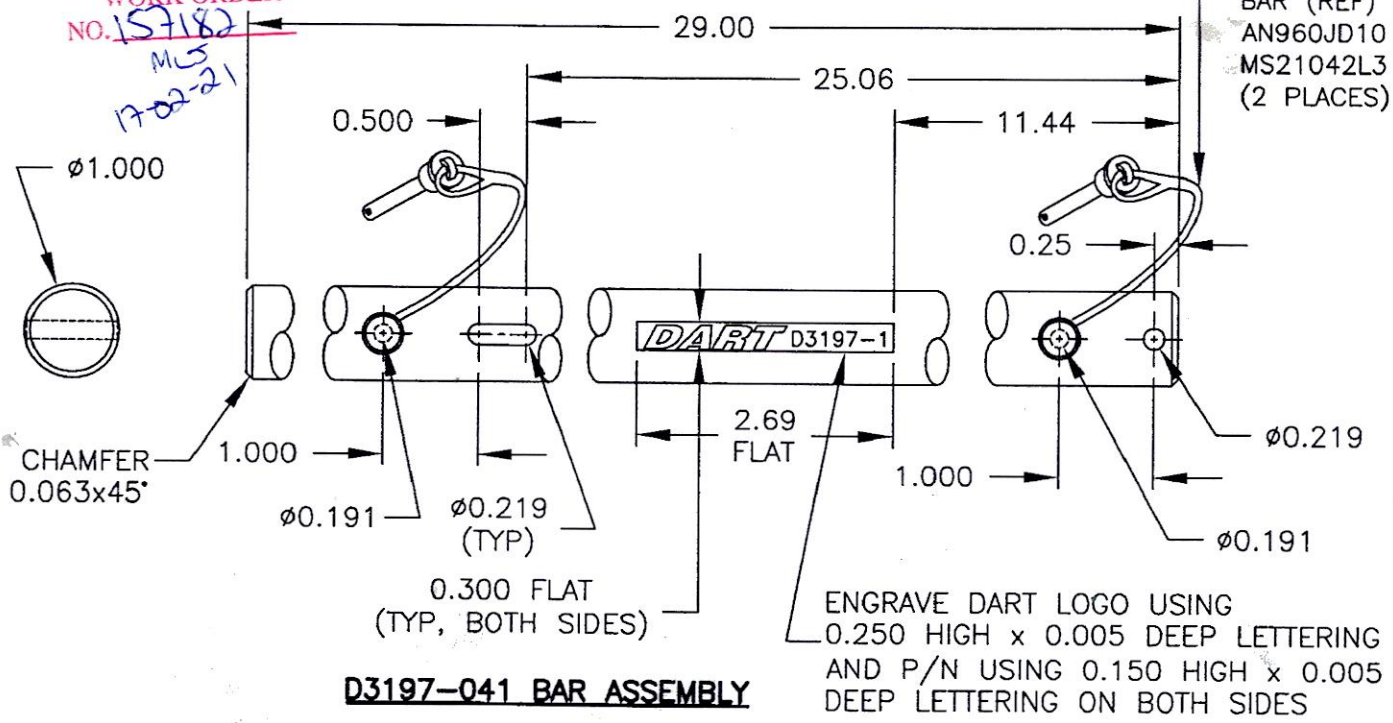
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

RELEASED

DART

SHOP COPY
RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 157182
ML5
17-02-21

- D3489-3-200 PIP PIN (1)
- D3242-1 TAG (1)
- MS27039-1-24 BOLT (1)
- AN960JD10 WASHER (1)
- D2690-5 LANYARD (1)
- AN960JD10 WASHER (1)
- BAR (REF)
- AN960JD10 WASHER (1)
- MS21042L3 NUT (1)
- (2 PLACES)



D3197-041 BAR ASSEMBLY

D3197-1 BAR

- 1) MATERIAL: 7075-T73 ROUND BAR (QQ-A-200/11 or QQ-A-225/9) ϕ 1.000 O.D. (REF DART SPEC. M7075T73R1.000)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) FOR TOOLING, IT IS ACCEPTABLE TO HAVE A 0.06 DEEP x 60° CENTER MARK AT EITHER END OF THE BAR

DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED		APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	06.01.10	TITLE	BAR	REV. B
		DRAWING NO.	D3197	SHEET 1 OF 1
		SCALE	1:1	
	A	03.07.01	NEW ISSUE	
	B	06.01.10	CHG PIP PIN; ADD D3242-1 TAG	

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